Work Orde September-23-13	r ID 107246			*107	7246*							Page 1	
Revision ID:	D4030-041			Accept	*N900	<u>)</u> 040	100	)* s	etup	Start Stop	*N.	S1*	<del></del>
		Qty: 1.00 1 Qty: 1.00	*1* *1*		Cust Item Customer:						*N!	S2*	ř
Approvals:	•		Date: 1309-2.			Date:		R	Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II	Opera Descr			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision N	br									•		
D4030	р												
*100  *100  Packaging  Packaging	Pick Ki	Мето		0.00				13/,	10/2.	3 (1	DAS 32 9-89		
*110 *110* HandFinish Hand Finishing	Assemi		label plate to size of D4086 or label, apply label ****	0.00 0.00 6 label, use scotchbrite r	ed pad to lightly				JU	13/16	olza.	DAS 33 9-89	10.
120 *120* QC Quality Control	QC5-I	nspect part comp	oleteness to step on W/O	0.00 das 27 0.00 9-89	-24			J	. <u></u>	, ————————————————————————————————————		·	

tr- ----

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFOR	MANCE / UPDA	TE	OA Classic	D-4	
				<del> </del>		<u> </u>		<del></del>			QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Ord	٠					Rework	1		Skid-tube (	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1		<b>├</b>	Small Fab	Pro	d. Eng. Coor.	Quality
		<del></del>				Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	]		Large Fab C	Composite		Supplier	
							_	<u> </u>					
Root					1	ption of work order update	1	Initial	Action		Sign &		
Cause	,	Date	Step	Qty	,	or Non-conformance	Cr	nief Eng	Descript	ion	Date	Verification	QC Inspector
Doc/Data			}				1						
Equip/Tooling			}										
Operator	L												
Material			4										
Setup		ļ	[										
Other	L												
Process													ĺ
Supplier		1	Į	1									
Training	Г	] ·				•							
Unapproved	Г	]	1			_							
						F	AUI	LT CATE	GORY				
Landi	ing (	Gear				General					-		<b>-</b>
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		inspect	ion Incomplete		Part Incorre	ct	Weld
	Г	Crushed/	Crimped			Burrs		Instruct	tions Incomplete/Unc	lear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		_
1		Lost Tro	a+			Countersink		Miclaho	alad		Positioned V	Mrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-23-13				*107	7246*			We are proposed to		Page 2
Item ID: Revision ID:	D4030-041	- <u> </u>		Accept	*N900	<b>04010</b> 0	)* s	etup	Start	*NS1*
Item Name:	Long Basket	Assembly (350)							Stop	*NS2*
Start Date: Required Date:	10/07/13 10/07/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				
Reference:										
Approvals:	Process Pla	an:	Date:	Tooling:	Da	nte:	R	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Da	nte:			Stop	*NR2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Rejo Qty		Reject Insp. Number Stamp
130		Identify as per dwg & St	ock Location:	0.00				,	1	
*130* Packaging		Memo		1998	07/90			3/1	ola5	DAS 6
Packaging										<b>9-89</b> ,
140 * <b>110</b> *		QC21- Final Inspection	- Work Order Release	0.00		$\mathcal{A}$	1/6	m	13,	/10/29

0.00

Memo

Quality Control

JWF. 10.29

DQA:	Date:	
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NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

										QA Closed:	Date	
Work Orde	ŕ:			• .	DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is		ı	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update	]		Large Fab	Composite	Recystor	Supplier	
Root				Descri	ption of work order update	İr	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		7 "				-						
		<u>.</u>	·	<u> </u>	F	AUL	CATE	GORY				
Landin	g Gear			·	General					_		
	<b>─</b>	/Crimped at on Strip in	Tube Extrusion		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misreae Offset Out of	ion Incomplete tions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tv	•			Folio	П	Outsido	e Dimensions				

Page 1/C

Work Order 1D:

107246

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

10.04.20 verified by:EC

**Start Date:** 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

3.23 verified by:EC IPP Rev:B as per dwg revB DD IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

IPP Rev D 12.03.27 per NCR12-1239 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	14.0000	· <del>_ · · · · · · · · · · · · · · · · · ·</del>	1	DA	s	······································
Placard, Max Load											3		
				<b>Location</b>		Loc Qty	<u>I</u>	Loc Code			9-8	39	
				ST093		14							
				105	131	10			10	5/31			
				886	11	1							
				962		1							
				985	119	2				<del> </del>			
D2530		Manufactured	No			100	Each	7.0000	1	-1	DA		
Handle Weldment										7144	33		
				<b>Location</b>		Loc Oty	1	Loc Code		,	9-8		
				ST255		7							
				103	3407	1							
				921	30	2							
				980	)72	4							
D2535		Manufactured	No			100	Each	135.0000	2	2		<b>AS</b>	
Spring												3	13-10-2
				Location		Loc Qty	1	Loc Code			9-	89 ·	•
				ST011		135							
					)552	98							
					2576	37			10:	2576			

										DQA:	Date	:
NCR: Y	'es / No				WORK ORDER NON-C	CONF	FORN	MANCE / UP	DATE	QA Closed:	 Date	
					1					QA Closed:	Date	·
Work Orde	or.				DISPOSITION	ŀ			AGAINST DI	EPARTMENT	/PROCESS	
WOIK OIG					Rework	1 l		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				····	Use-as-is	<b>1</b> ].	Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Ini	tial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											ļ	
Operator												•
Material												
Setup												
Other		1										
Process												
Supplier												
Training												
Unapproved					· · · · · · · · · · · · · · · · · · ·					<u> </u>		
						AULT	CATE	GORY				
Landi	ng Gear			_	General				_	7	_	<b>-</b> .
	Bending			⊢	Bend	$\vdash$	irain		_	Ovalized	_	Pressure/Forced
	_	ot Conce	ntric to O	′s  _	BOM/Route	$\vdash$	lardwa		<u> </u>	Over/Under	<b>⊢</b>	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	$\vdash$		on Incomplete	<u> </u>	Part Incorre	}	Weld
	Crushed/Crimped Burrs							ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	<b>├</b> ──┤		nance	_	Part Moved		
	Heat Tre				Countersink	$\vdash$	∕islabe		<u> </u>	Positioned V		<b>¬</b>
	Inspection		Tube		Cut Too Short	$\vdash$	/lisread		L.	Power Loss/	Surge	Other
	Ripples in				Drill Holes	$\mathbf{H}$	Offset					
	<del></del>		Extrusion		Drawing	$\vdash$		Calibration				
	Turning 9	Sequence	)	1	Finish	I Id	of S	eguence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:44:24 AM

Work Order ID:	107246										
Parent Item:	D4030-041						Start	Date: 10/07/13	R	equired Date: 10	)/07/13
Parent Item Name:	Long Basket Asse	mbly (350)					Start	t Qty: 1.00	F	Required Qty: 1.	00
D2537 Bushing		Manufactured	No		100	Each	134.0000	2	2.	DAS 33	
<del>-</del>				<u>Location</u>	Loc Oty		Loc Code			9-89	
				ST008	30						
				102982	. 30						
				ST011	104				<del></del> ./		
				100454	38			1004	<i>54</i>		
				103608 103861	24 4(						
				98426	41		•				
D3913-041 Long Basket Base Asser	nby, 350	Manufactured	No		100	Each	0.0000	1310	123	58 (Jx)	11/12/10/24
D3914-041 Long Basket Lid Assem	bly (350)	Manufactured	No		100	Each	0.0000	1316=	1204	(IL)	Il 10/24
<b>D3917-3</b> Washer		Manufactured	No		100	Each	207.0000	6	6	DAS	
				<b>Location</b>	Loc Qty		Loc Code			33 9-89	
				ST072	20'	1				0.00	
				100397	46	•		2×1003	397		
				103536	4			441033	536		
D. 40. F. 4				104859	120						
D3953-3		Manufactured	No		100	Each	35.0000	2	2		13-10-13
Gas Spring Stud, Lid										DAS	
				Location	Loc Qty		Loc Code			<b>33</b> 9-89	
	, ·			GA 07502					<del></del>	0.00	
				87592	2						
	ř			ST076 102196	3-2			102	196		
				88494	1:			_1 &	1110		
•				00.7.	•						

DQA:	Date:	

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

									QA Closed:	Date	<b>:</b>		
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS			
Part N	0.				Rework Scrap Use-as-is Work Order Update	Tho	Skid-tube  Machining ermoforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	Initia	A	Action	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator							İ						
Material		Ì							İ				
Setup			1										
Other		1											
Process						1							
Supplier			1				Ì						
Training													
Unapproved										<u></u>			
					F	AULT CA	TEGORY						
Landin	ng Gear				General				<b>-</b>	_	<b>_</b>		
L	Bending				Bend	Grai	n		Ovalized	L	Pressure/Forced		
ļ	Centre No	ot Conce	ntric to (	D/S	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure		
	Cracks			<u> </u>	Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld		
	Crushed/	Crushed/Crimped Burrs				Instr	uctions Incomplete	e/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
	Cuffs Contamination				Mai	ntenance		Part Moved					
	Heat Treat Countersink				Misl	abeled		Positioned V	Vrong				
,	Inspection Strip in Tube Cut Too Short					Misr	ead		Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes					Offset							
	Torque Waves in Extrusion Drawing					Out	of Calibration			*****			
	Turning Sequence Finish						Out of Sequence						
	Waye/Twist in Tube						ide Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:44:24 AM

Work Order ID:	107246								
Parent Item:	D4030-041					Start	<b>Date:</b> 10/07/13	F	Required Date: 10/07/13
Parent Item Name:	Long Basket Assembly (350)					Star	t <b>Qty:</b> 1.00		Required Qty: 1.00
D3953-7 Spring Spacer	Manufactured	No		100	Each	84.0000	2	2	DAS 33 9-89
			Location	Loc Oty		Loc Code			9-69
			ST076	84				4.7	
			100414	14			11-1604	14	
			102928	24				— —	•
			105465	45			# 105	465	
			99148	1			<u> </u>		
D3953-9 Gas Spring Washer	Manufactured	No		100	Each	69.0000	2	2	DAS
			Location	Loc Qty		Loc Code			33 9-89
						<u>not cout</u>			9-89
			ST076 102166	69					
			103615	21 46			1036	15	
			94719	2			1000	<del>, -</del>	
			95127	0					
D3953-17	Manufactured	No	, , , , , , , , , , , , , , , , , , ,	100	Each	14.0000	2		
Gas Spring Spacer	Manufactured	140		100	Lucii	14.0000	<b></b>		02860//
			<b>Location</b>	Loc Qty		Loc Code			
			ST075	14					
			100353	14					
D3953-19	Manufactured	No		100	Each	11.0000	1	1	DAS
Gas Spring Bracket	Manaractarea								33
, 3			Location	Loc Qty		Loc Code			9-89
			ST077	11		<u> Doc Couc</u>			
			100341				1003	41	
D2062 44			100341	110		11.0000	,,,,,,	Ц	
D3953-21	Manufactured	No		100	Each	11.0000	ı	1	DAS 13-10-
Gas Spring Bracket							<u> </u>		
			<b>Location</b>	Loc Oty		Loc Code			, <del>38</del> 92
			ST077	11					
			100404	11			1004	04	
								•	

												DQA:	Da	ate:	
NCR:	⁄es	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UP	PDATE					
												QA Closed:	D	ate:	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
WOIR OIG	٠,,	· · · · · ·				Rework	1		Skid-tube	Crosstube		7	Water Je	t∏	Engineering
Part I	۷o.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor		Quality
					· · · · · · · · · · · · · · · · · · ·	Use-as-is	1	Thern	noforming	Finishing		Rec/Sto	re/Packaging	<u> </u>	Other
NCR I	Vo.					Work Order Update	]		Large Fab	Composite		]	Supplie	r	
			· · · · ·	,			_								
Root				•	1	ption of work order update		Initial	i	ction		Sign &	_	ł	
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription		Date	Verification	วท	QC Inspector
Doc/Data							1								
Equip/Tooling															
Operator				•											
Material															
Setup					Ì										
Other															
Process															
Supplier							1						į		
Training															
Unapproved															
						F	AUL	LT CATE	GORY						
Landi	ng (	Gear				General		_				_			-
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs		instruct	ions Incomplete,	/Unclear		Part Lost/M	issing		Wrong Stock Pulled
1		Cuffs				Contamination		Mainte	enance			Part Moved			-

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:44:24 AM

Work Order ID: Parent Item: Parent Item Name:	107246 D4030-041 Long Basket Assembly (350)						Date: 10/07/13  Qty: 1.00		Required Date: 10/07/13 Required Qty: 1.00
D3969-3 Gas Spring	Manufacture	d No		100	Each	49.0000	1	1	DAS 33 9-89
			Location	Loc Qty		Loc Code			9-69
			ST262	49					
			100611	32			10061	T	
			99623	17			<u> </u>		
AN3-14A	Purchased	No		100	Each	115.0000	4	4	
Bolt							(a		DAS
			Location	Loc Oty		Loc Code			33
			ST351	14					9-89
			m12570						
			ST511	001					
			m12619	100					
			ST512	1			12619	2	
			123759	1					
AN3-16A	Purchased	No		100	Each	159.0000	2	2	
Bolt									DAS 13-10-2
			Location	Loc Qty		Loc Code			33
			GA	47					9-89
			117441						
			ST352	112					
			122407						
			M1259				Maria de la companya della companya della companya della companya de la companya della companya	_	
			M1261				1261	192	

										DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-C	ONFOR	MANCE / UPI		QA Closed:	Date:	
Work Orde	·r·					DISPOSITION			AGAINST DEI	PARTMENT	/PROCESS	
Part N	Part No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chief En	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							ĺ				1	
Operator												
Material												
Setup			1									
Other			}	ļ			İ					

**FAULT CATEGORY Landing Gear** General Bend Ovalized Pressure/Forced Bending Grain BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Part Moved Contamination Maintenance Positioned Wrong Mislabeled Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Finish Out of Sequence Turning Sequence Wave/Twist in Tube Folio Outside Dimensions

Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:44:25 AM

Work Order ID:	107246										
Parent Item:	D4030-041						Start I	Date: 10/07/13	3	Required Date: 10	/07/13
Parent Item Name:	Long Basket Assembly (350	)					Start	<b>Qty:</b> 1.00		Required Qty: 1.0	00
AN5-17A Bolt	Purch	ased	No		100	Each	403.0000	4	4	DAS	, to the state of
			Lo	cation	Loc Qty		Loc Code			9-89	
			GA	<b>A</b>	36						
				117872	36						
			ST	337	4						
				124215	2						
				124805	2						
			st5	03	213						
				m126176	213						
			ST	514	150			126	176		
				125388	150						
AN4-12	Purch	ased	No		100	Each	119.0000	3	3		
Bolt										DAS	op.
			Lo	cation	Loc Qty		Loc Code			33	
			ST	356	119					9-89	
				124805	5						
				m125709	50						
				m126193	64			126	193		
AN310-4	Purch	ased	No		100	Each	138.0000	3	3	DAS 33	13-10-23
Nut										9-89	13-10-0
			Lo	<u>cation</u>	Loc Qty		Loc Code			3 00	
			ST	342	138						
				112969	2						
				122800	2				<u> </u>		
				M125716	34			125	716		
				M126400	50						
				M126872	50						

DQA: Date:

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

	DISPOSIT										QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N	 lo					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verificatio	n	QC Inspector
Doc/Data	$\neg$					. , ,								
Equip/Tooling													ł	
Operator									:				١	
Material														
Setup														
Other											ļ			
Process													İ	
Supplier							1							
Training														
Unapproved														
						F	AUL	T CATE	GORY					
Landir					<del></del>	General					7			
	$\overline{}$	ending			<u> </u>	Bend		Grain			Ovalized		$\vdash$	Pressure/Forced
	$oldsymbol{oldsymbol{ o}}$	entre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			Over/Under		$\vdash$	Temperature/Cure
	${f H}$	racks			· L	Broken/Damaged		•	ion Incomplete	ļ	Part Incorred		-	Weld
	$\vdash$	crushed/0	Crimped		<u></u>	Burrs		1	tions Incomplete,	/Unclear	Part Lost/Mi	issing		Wrong Stock Pulled
	<del></del>	Cuffs				Contamination	<u> </u>	Mainte			Part Moved			
	$\vdash$				Countersink		Mislabe		<u> </u>	Positioned V	_	_		
	Inspection Strip in Tube Cut Too Short			-		Misrea	d	L	Power Loss/	Surge		Other		
	Ripples in Bend Drill Holes			_	Offset									
		orque W	aves in E	Extrusio	n L	Drawing		4	Calibration					
	╚	Turning S	equence	!		Finish	$\perp$	Out of	Sequence					
I	i k	Maya/Tu	ict in Tub	ha		Eolio	1	Outcide	Dimonsions					

September-23-13 11:44:25 AM

Work Order ID: Parent Item: Parent Item Name:	107246 D4030-041 Long Basket Assem	nbly (350)						Date: 10/07/13  Oty: 1.00		Required Date: 10/0 Required Qty: 1.00	
<b>AN310C4</b> Nut		Purchased	No		100	Each	126.0000	2	2	DAS 33	
				<u>Location</u>	Loc Oty		Loc Code			9-89	
				ST342	126						
				122993	24			1229	793		
				123831	2						
				126192	50						
				M125952	50						
MS21042L3 Nut		Purchased	No		100	Each	5,946.0000	6	6	DAS 33	13-10-
				Location	Loc Qty		Loc Code			9-89	
				FP001	3			4			
				122141	3						
				GA	18						
				122452	18						
				ST314	304						
				111668	1						
				117885	32						
				119017	55						
				119075	138		•				
				123265	43						
				M126036	35						
				ST506	1249						
				123900	870						
				124291	379						
				ST510a	4372						
				M126275	372				<del></del>		
				M126333	4000			126	<u>333</u>		

											DQA:	Date	:
NCR: Y	es/	/ No				WORK ORDER NON-C	O	VFORN	MANCE / UP	DATE	QA Closed:	Date	
						DISPOSITION		•		AGAINST DE			•
Work Orde Part N NCR N	- . No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
				<del> </del>		· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY				
Landi	Centre Not Concentric to O/S Cracks Br Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabe Misread	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	1 Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:44:25 AM

Work Order ID:	107246								-	
Parent Item:	D4030-041					Start I	Date: 10/07/13		Required Date:	0/07/13
Parent Item Name:	Long Basket Assembly (350)					Start	<b>Qty:</b> 1.00		Required Qty: 1	.00
<b>MS21042L5</b> Nut	Purchased	No		100	Each	999.0000	4	4	33 9-89	No.
		. <u>L</u> e	<u>ocation</u>	Loc Qty		Loc Code				
		ST	Г314	39						
			125654	39						
		ST	Γ506	1						
			123900	1						
		st	507	959					_	
			125535	959			]25	535	Ī	
MS24665-151 Cotter Pin	Purchased	No		100	Each	183.0000	3	3	DAS	
		L	<u>ocation</u>	Loc Qty		Loc Code			<b>33</b> 9-89	
		G		28						
			17566	28						
		S	Т323	155						
			122802	20						
			124859 125646	4 131			125	1646		
MS24665-300	Purchased	No	123040	100	Each	151.0000	2	2	DAS 33	13-10-23
COTTER PIN									9-89	
		<u>L</u>	ocation	Loc Qty		Loc Code			- 03	
		G		37						
			118234	37						
		S	T299	114			1011			
			124555	114			194	<u> </u>		

												DQA:	Da	ate: _	
NCR:	⁄es	/ No				WORK ORDER NON-C		VFORM	MANCE / UP	DATE		QA Closed:		ate:	
						I	1					QA Closed.		ne.	
Work Orde	a r					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	٠					Rework	1		Skid-tube	Crosstube		]	Water Je		Engineering
Part N	JO.					Scrap	1	۱ ،	Machining	Small Fab	_	Pro	d. Eng. Coor	$\vdash$	Quality
1 """	10.					Use-as-is	1 1		noforming	Finishing		4	e/Packaging	$\vdash$	Other
NCR I	۷o.					Work Order Update	1		Large Fab	Composite		,	Supplie	-	
	•					'						,			
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &	-		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data															
Equip/Tooling			1		Ì		ì								
Operator	Ш			!											
Material	Ш		ĺ												
Setup					1										-
Other															
Process	<u> </u>						l								
Supplier			Ì												
Training							1								
Unapproved									L						·
ļ							AUL	T CATE	GORY						
Landi		t			_	General To		1				1			l
	┡	Bending				Bend	<u></u>	Grain			$\vdash$	Ovalized		-	Pressure/Forced
	_	Centre N	ot Concei	ntric to	O/S	BOM/Route	-	Hardwa			_	Over/Under		_	Temperature/Cure
	-	Cracks	Catana I		<u> </u>	Broken/Damaged	$\vdash$	4 '	ion Incomplete	// to along	-	Part Incorred		-	Weld
	$\vdash$	Crushed/	Crimpea		F	Burrs	$\vdash$	4	ions Incomplete/	unclear	H	Part Lost/Mi	ssing		Wrong Stock Pulled
1	I .	Cuffs			1	Contamination	1	Maintenance Part Moved							

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

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September-23-13 11:44:25 AM

Work Order ID:	107246												
Parent Item:	D4030-041							Start D	ate: 10/	07/13	Require	d Date: 10/07/13	3
Parent Item Name:	Long Basket Asser	mbly (350)						Start (	<b>Qty:</b> 1.0	0	Require	ed Qty: 1.00	
NAS1149F0432P WASHER		Purchased	No			100	Each	2,044.0000	6	6	აა		
				Location		Loc Qty		Loc Code	X . /		9-89		
				ST295	<u>.</u>	<u>Lot Qty</u> 81		Loc Code					
				31293	122151	2							
					123522	4			_				
					123900	6							
					124580	13							
					124859	15							
					125268	41							
				ST510a		1963							
					M126221	1963				126221			
NAS1149F0563P		Purchased	No			100	Each	586.0000	4	4	DA	S	
Washer									17.77		33		
				Location	<u>1</u>	Loc Oty		Loc Code			9-8	9	
				ST295		586							
					121350	586				21350			
NAS1149F0332P		Purchased	No			100	Each	8,538.0000	8	8	D	AS 4.7	
Washer												3 /3 89	-10-
				Location	1	Loc Qty		Loc Code			<i>3</i> -	09	
				GA		182							
					122063	182			_				
				ST294		158							
					122063	158							
				ST295		3							
					123352	3							
				st510		3195							
					123900	3195							
				ST510a		5000			7	23900			
					125646	5000							

				•							DQA:	Date:	
NCR: Y	es ,	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE		· <u> </u>	
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
l Work Orde	-'' –			-		Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	۱o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			·			Use-as-is	]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No					Work Order Update	]		Large Fab	Composite		Supplier	
			ı								- C: 0		1
Root					l .	ption of work order update	1	nitial		tion ·	Sign &	\	06 la sa sata a
Cause	$\perp$	Date	Step	Qty		or Non-conformance	Cr	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling							1						
Operator							ļ				İ		
Material			ļ										
Setup													
Other					j								
Process													
Supplier			1										
Training	П												
Unapproved				-									
						F	AUI	T CATE	GORY			· · ·	
Landi	ng G	ear				General		_			_		-
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	П	Centre No	ot Conce	ntric to	o/s $\Gamma$	BOM/Route		Hardwa	ire		Over/Under	rtolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

## **Picklist Print**

September-23-13 11:44:25 AM

Page 9

Work Order ID:

107246

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date:** 10/07/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

33

9-89

NAS1149C0432R

Purchased

No

ST510a

m126221

100

4642

4642

Each

7,280.0000

Loc Code

2

2

DAS 13-10-23

WASHER

 Location
 Loc Qtv

 ST292
 2638

 119124
 6

 121255
 32

 121825
 8

 122441
 55

 m125807
 2545

126221

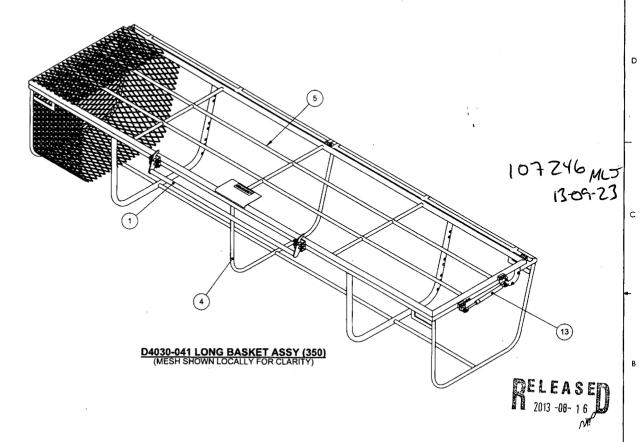
		DQA:	Dat	æ:
NCR.	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date	<b>e:</b>	
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N						Rework Scrap Use-as-is Work Order Update		ſ	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root	-	1			Descri	ption of work order update		nitial	Act	ion	Sign &		乛	
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification		QC Inspector
Doc/Data	$\dashv$	Date	step	Qty		or won-comormance	-	ici Liig	Desci	iption	Dute	Vermedilon	$\dashv$	Q map coto.
Equip/Tooling	$\dashv$													
Operator	$\dashv$						1						Ì	
Material	$\Box$													
Setup	$\Box$													
Other	Ħ													
Process														
Supplier	П													
Training														
Unapproved														
						F	AUL	T CATE	GORY					
Landi	ng Ge	ar				General		_			-	_		-
	В	ending				Bend		Grain			Ovalized			Pressure/Forced
	C	entre No	t Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance		Temperature/Cure
	Cı	racks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct _	-	Weld
	C	rushed/0	Crimped		L	Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	╝	Wrong Stock Pulled
		uffs			_	Contamination		Mainte	enance		Part Moved			
	Щн	eat Trea	t			Countersink		4	Mislabeled		Positioned Wrong			1
	$\vdash$	•	n Strip in	Tube		Cut Too Short			Misread		Power Loss/	Surge		Other
	∐ R	ipples in	Bend		L	Drill Holes		Offset					_	
	<b>∐</b> ™	orque W	aves in E	Extrusio	n	Drawing		4	Calibration					
	Turning Sequence		Finish	1	Out of S	Seguence								

Outside Dimensions

Wave/Twist in Tube

١	ITEM	QTY -041	P/N	DESCRIPTION		
ı		X	D4030-041	LONG BASKET ASSY (350)		
	1	1	D2530	HANDLE WELDMENT		
	2	2	D2535	SPRING		
	3	2	D2537	BUSHING		
Ы	4	1	D3913-041	LONG BASKET BASE ASSY (350)		
1	5	1	D3914-041	LONG BASKET LID ASSY (350)		
ı	6	6	D3917-3	WASHER		
ı	7	2	D3953-3	GAS SPRING STUD, LID		
Ī	8	2	D3953-7	GAS SPRING SPACER		
- [	9	2	D3953-9	GAS SPRING WASHER		
Ī	10	2	D3953-17	GAS SPRING SPACER		
4	11	1	D3953-19	GAS SPRING BRACKET		
Ī	12	1	D3953-21	GAS SPRING BRACKET		
-	13	1	D3969-3	SPRING		
	14	4	AN3-14A	BOLT, MACHINE		
	15	2	AN3-16A	BOLT, MACHINE		
- [	16	3	AN4-12	BOLT, MACHINE		
	17	4	AN5-17A	BOLT, MACHINE		
-	18	2	AN310C4	NUT, PLAIN, CASTELLATED		
Ī	19	3	AN310-4	NUT, PLAIN, CASTELLATED		
- [	20 .	6	MS21042L3	NUT, SELF-LOCKING		
	21	4	MS21042L5	NUT, SELF-LOCKING		
	22	2	MS24665-300	COTTER PIN		
	23	3	MS24665-151	COTTER PIN		
ĺ	24	2	NAS1149C0432R	WASHER		
+	25	6	NAS1149F0432P	WASHER		
[	26	8	NAS1149F0332P	WASHER		
ſ	27	4	NAS1149F0563P	WASHER		



DRAW	<u> </u>	AJS	DART AEROSPA		_
DESIG	ú T	AJS	DART AFROCO	OF 13	P.D.
REV.	REV.		SCRIPTION	BY	DATE
Α	NEW ISS	ŲĖ		JPH	10.03.16
В			19A: BOM & (D3-3)	JPH	10.04.06
QTY FOR ITEMS #30 & #31 C (B8-1); QTY FOR ITEM #3 W REQUIRED, AFFECTS SEC			1 UNDER -043 WERE MISSING WAS 4 (D6-1), ONLY 2 ARE CTION C-C (D3-3).	МВ	10.07.23
D REFORMAT FOR CLARITY. MULTIPLE VIEWS DUE TO			Y. PICTORIAL UPDATE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18

DESIGN	AJS	DART AEROSPACE LTD	1
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P	DRAWING NO.	REV. D
MFG. APPR.	1/20	¬ <b>D4</b> 030 <sub>sнi</sub>	EET 1 OF 4
APPROVED	Tuls	TITLE	SCALE
DE APPR.	<del>- W</del> -	LONG BASKET ASSY (350)	NTS
DATE		COPYRIGHT © 2010 BY DART AEROSPACE LTD	· · · · · · · · · · · · · · · · · · ·

13.07.18

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

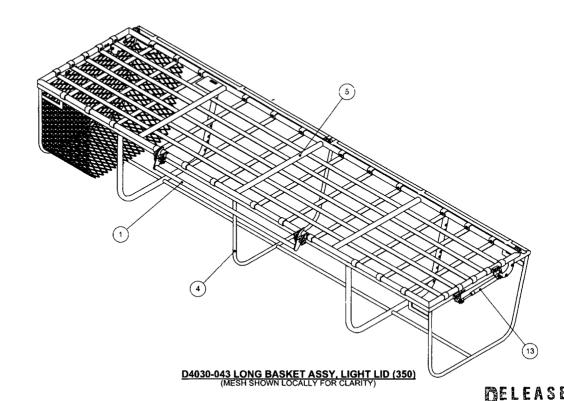
107246

D

С

В

į	ITEM	QTY -043	P/N	DESCRIPTION		
Ī		Х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)		
	1	1	D2530	HANDLE WELDMENT		
)	2	2	D2535	SPRING		
	3	2	D2537	BUSHING		
	4	1	D3913-041	LONG BASKET BASE ASSY (350)		
	5	1	D3915-041	LIGHT LID ASSY, LONG BASKET		
	6	6	D3917-3	WASHER		
	7	2	D3953-3	GAS SPRING STUD, LID		
ľ	8	2	D3953-7	GAS SPRING SPACER		
	9	2	D3953-9	GAS SPRING WASHER		
	10	2	D3953-17	GAS SPRING SPACER		
	11	1	D3953-19	GAS SPRING BRACKET		
	12	1	D3953-21	GAS SPRING BRACKET		
	13	1	D3969-3	SPRING		
	14	4	AN3-14A	BOLT		
	15	2	AN3-20A	BOLT		
	16	3	AN4-12	BOLT		
ĺ	17	2	AN5-17A	BOLT		
:	18	2	AN5-21A	BOLT		
	19	3	AN310-4	NUT, PLAIN, CASTELLATED		
	20	2	AN310C4	NUT, PLAIN, CASTELLATED		
	21	6	MS21042L3	NUT, SELF-LOCKING		
ı	22	4	MS21042L5	NUT, SELF-LOCKING		
	23	3	MS24665-151	COTTER PIN		
	24	2	MS24665-300	COTTER PIN		
-	25	6	NAS1149F0432P	WASHER		
	26	4	NAS1149F0563P	WASHER		
	27	3	NAS1149F0332P	WASHER		
	28	2	NAS1149C0432R	WASHER		



NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	0	DRAWING NO. REV. D
MFG. APPR.	177	D4030 SHEET 2 OF 4
APPROVED	MA	TITLE SCALE
DE APPR.	4	LONG BASKET ASSY (350) NTS
DATE 13.0	7.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS GOODWING IS PREVALE AND COMPETED ON COMMENT OF EXPRESS CONDITION THAT IS IN MOTTO BY LISTO FOR MY PROPESS OR COMPETED ON COMMENCIANTE TO ANY OTHER PRISION WITHOUT

